

Supa-Fil® 21N

2.1 VOC 2K Polyurethane Primer/Filler



DESCRIPTION

Supa-Fil 21N is a 2K Polyurethane 2.1 VOC Primer/Filler that may be used over fiberglass, previously painted surfaces, pretreated ferrous and non-ferrous metals. Supa-Fil 21N is a 2.1 VOC 2K polyurethane primer that demonstrates excellent filling and sanding characteristics.



COMPONENTS

- 21N..... Supa-Fil
- HPC218 Activator
- X01 Fast Exempt Reducer



MIXING RATIO

Supa-Fil 21N must be activated. Mix four (4) parts Supa-Fil 21N to one (1) part HPC218 Activator (4:1). Supa-Fil may be reduced up to 25% with X01 Reducer.



POT LIFE @ 77°F (25°C)

2 hours
(Reduction may extend pot life)



CLEAN UP

Valspar Refinish 100 Thinner
(Check local regulations)



ADDITIVES

ACCELERATOR: T566 - up to 2 ounces per gallon
FISHEYE: Not recommended
FLEX ADDITIVE: N/A

Note: Do not spray when surface temperature is below 50°F (10°C).



SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with 170 AquaClean and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate.
- Clean surface with 170 AquaClean and wipe dry with clean cloth before product flashes.



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SUBSTRATES

- Properly treated steel and aluminum
- Fiberglass
- VP Series Epoxy Primer/Sealer
- Properly sanded OEM finishes
- SunLock II 88 Series
- SMC
- DTM 2000



APPLICATION

- Spray medium wet coats to desired film thickness.
- Allow 10-15 minutes between coats or **until finish is dull.**

TINTING

- May be tinted with up to one (1) pint per gallon of any Universal Intermix Tint
- Tint should be added BEFORE activation



FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	10-15 Minutes
To Sand (if desired)	1.5 Hours
(Longer dry times give optimum sand scratch resistance)	
To Topcoat	60 Minutes



INFRARED CURE

See Infrared Curing Information on pages 78



GUN SETUPS CONVENTIONAL

Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.8 mm - 2.0 mm
 HVLP	 1.6 mm - 1.8 mm



AIR PRESSURES

Conventional @ Gun

	PANEL	OVERALL
Gravity	30-35 psi.	40-45 psi
Siphon	30-40 psi.	45-55 psi

HVLP @ Cap

8 - 10 psi.	8 - 10 psi
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PHYSICAL DATA

VOC (Coating Ready-To Spray)	2.07 lbs/gal (248 g/l)
VOC (Material Ready-To-Spray)	1.66 lbs/gal (199 g/l)
Volume Solids	56%
Theoretical Coverage	901 sq. ft. per mil per gallon
Recommended DFT	not to exceed 5 mils.
Zahn #2 Viscosity (RTS)	27-30 seconds